

Work Order ID 105595

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Item ID: D2695-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Leg
 Start Date: 8/08/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/08/13 Req'd Qty: 1.00 *1* Customer:
 Reference: RE-POWDERCOAT *REWORK*

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2695	Rev C								
140	Chemical Conversion Coat per QSI005 4.1	0.00							<i>DA 05 13/08/13</i>
140									
HandFinish	Memo	0.00							
Hand Finishing	PULL FROM STK: 1 X D2695-1 B15056 STRIP COMPLETELY RE-ALODINE								
150	Black Sandtex (Ref: 4.2.5.7) per QSI005 4.3	0.00							
150	<i>white</i>								
Powdercoat	Memo	0.00							
Powder Coating	REPOWDER COAT WHITE PER QSI005 START TIME: <i>8:30</i> OVEN TEMPERATURE: FINISH TIME: <i>9:00</i>								<i>1x m 13/08/14</i>
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							<i>1x d 13/08/14</i>
Quality Control									

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 Required Date: 8/08/13 Req'd Qty: 1.00 *1* Customer:
 Reference: RE-POWDERCOAT

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>ST230</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY SING NEW B.N								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

1X _____ SP
 13-8-15

13/8/20 DJ

MLJ 13-08-15

Picklist Print

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Parent Item: D2695-1

Parent Item Name: Leg

Start Date: 8/08/13

Required Date: 8/08/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C00.11.01Removed P/O for Powder Coat - in house processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2695-1 Leg		Manufactured	No				Each	3.0000		1	5096x1		h

Location

Loc Qty

Loc Code

Mezz.

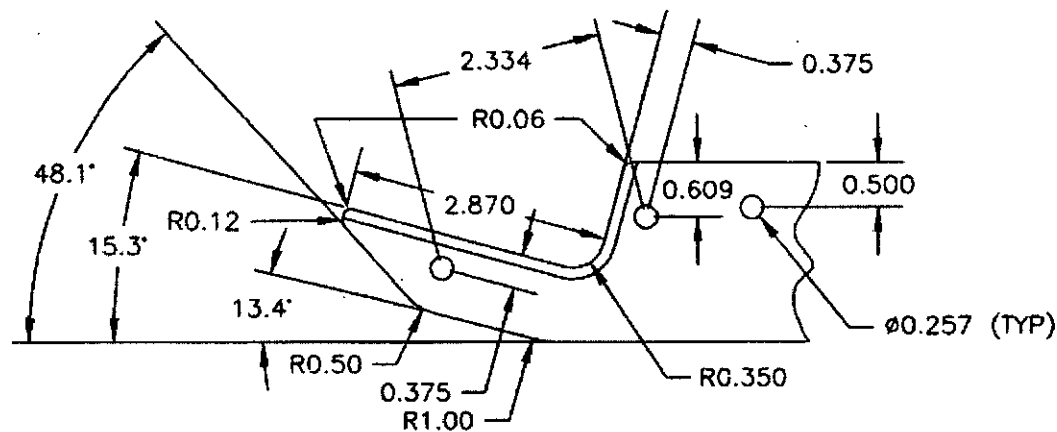
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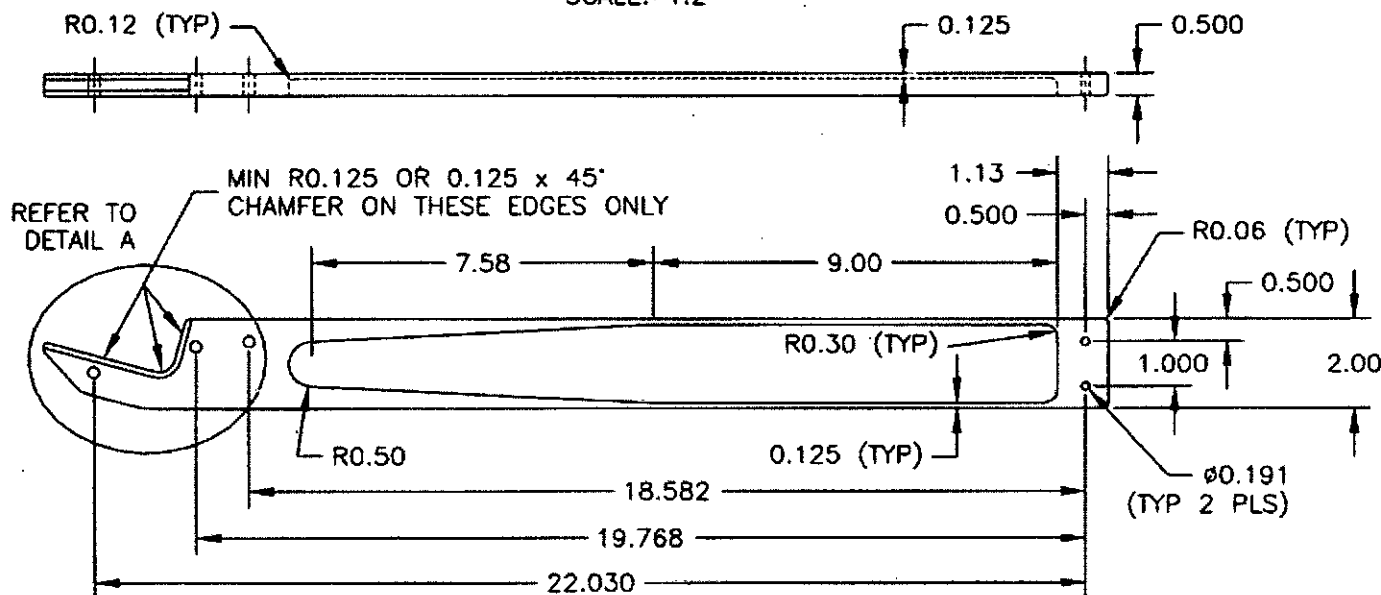
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DART**RELEASED**
KE 99.11.19

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>KE</i>	APPROVED <i>KE</i>	HAWKESBURY, ONTARIO, CANADA
DATE 99.11.03	DRAWING NO. D2695	REV. C
	TITLE STA 84 LEG	SHEET 1 OF 1
A	97.09.10	NEW ISSUE
B	99.10.20	UPDATE TOLERANCE, DELETE ENGRAVING
C	99.11.03	CHANGED GEOMETRY IN DETAIL A ADDED FINISH



DETAIL A
SCALE: 1:2



D2695-1 LEFT HAND (SHOWN)
D2695-2 RIGHT HAND (OPPOSITE)

NOTE: DEBURR ALL EDGES R0.03 - R0.06

MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-225/8 OR QQ-A-200/8 OR QQ-A-250/11)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT PER DART QSI 005 4.3 WHITE (4.3.5.1) OR

GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7)

